

Work Order ID 159719

Tuesday, April 18, 2017 11:32:54 AM

159719

Page 1

Item ID: D2646

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Cap

Start Date: 4/18/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan:

Date: APR 18 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2646	Rev C

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 35991 1-Spin as per Dwg D2646 2-Material release
note required
Vendor: Sieg's Manufacturing

50

APR 18 2017

110

0.00

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

1.00

Packaging

Ensure Material Release Note is attached

50x Sp 17-5-19

120

0.00

120

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

50

DAS
38
9-89

MAY 19 2017

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Item ID: D2646 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Cap
 Start Date: 4/18/2017 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 5/18/2017 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				50x			17/05/30 DAS 36 9-89
	Memo	1.50							
	1-Drill using DT8026 as per Dwg D2646.2-Open holes to .297 as per Dwg D2646.3-Deburr								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				50			DAS 38 9-89
	Memo	1.00							MAY 31 2017
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				(21)	17-07-11		BEB
	Memo	1.33							
	Hand Finishing								

QC7 → (21) 17-07-11 PD.

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Item ID: D2646

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cap

Start Date: 4/18/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

START TIME: _____

FINISH TIME: _____

OVEN TEMPERATURE: _____

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

180

Small Fab

0.00

180

Small Fab

Small Fab

Memo

Install inserts as per Dwg D2646

N/A see w/o 162284

N/A PD

N/A w/o 162284

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Item ID: D2646 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Cap
Start Date: 4/18/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 5/18/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O <i>MA</i> Memo	0.00 1.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : FP001	0.00 0.50							<i>21</i> JUL 12 2017 DAS 13 9-89
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 5.00							<i>17/7/13</i> DAS 21 9-89 JUL 12 2017

Picklist Print

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Work Order ID: 159719

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Parent Item: D2646

D2646

Parent Item Name: Aft Cap

Start Date: 4/18/2017

Required Date: 5/18/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: G05.08.22Hole size revised in Step 5KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130	AEIS8-1032-130	Purchased	No			110	Each	2,515.000	2	100			
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AI S7-1032-130

**

Rivnut

Location	Loc Qty	Loc Code
PG	100	
M128649	50	
M136048	50	
FP001	2207	
M128649	155	
M136579	2052	
ST556	208	
M136048	208	

D2646P	Purchased	No				180	Each	0.0000	1	50			
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D2646P

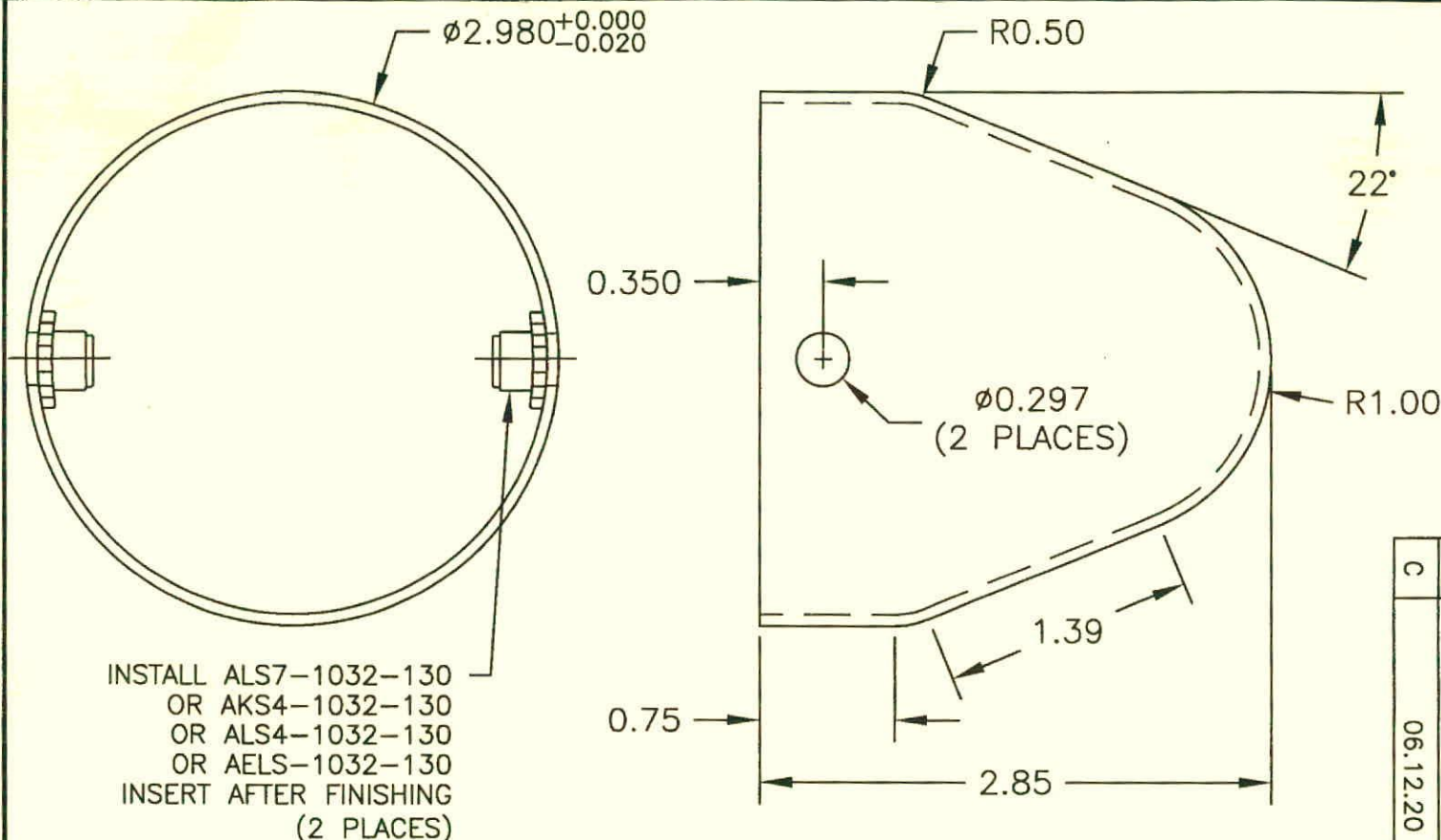
**

Aft Cap

50 x SP175-19.



DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.	REV. C
CHECKED		APPROVED	DRAWING NO.	
DATE	06.12.20		TITLE	SHEET 1 OF 1
			AFT CAP	SCALE 1:1
A		97.03.25	NEW ISSUE	
B		05.04.01	CHANGE TO CLOSED INSERTS	
C		06.12.20	CHANGE TO OPEN ENDED INSERTS	



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DAS
13
9-89

APR 18 2017

W10:159719

RELEASED
07.02.12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35991**

Purchase Order Date 4/18/2017 12:42:40 PM

PO Print Date 4/18/2017

Page Number 1 of 2

Order From :

VC-SIE001

Ship To : DART AEROSPACE LTD

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

APR 18 2017

Contact Name

Vendor Phone

604 530 7455

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2646P AS PER DWG D2646 REV. C B159719	Aft Cap	5/17/2017 Yes 5/17/2017 2017-5-19	50.00 Each	\$6.70	\$335.00
Line Total:					DAS 38 9-89	\$335.00
3	71401-45	PROCUREMENT QUALITY CLAUSES	5/17/2017 No 5/17/2017	1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents						

Note:

4/18/2017



Sieg's Manufacturing Ltd.

Quality Metal Spinning

Website: www.siegsmf.com

6236 205 Street Langley, British Columbia, Canada V2Y 1N7

Phone: (604) 530-7455 ~Email: accounts@siegsmf.com

Packing Slip

Packing Slip No.:

48106

Date:

05/12/2017

Page:

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Sold to:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO K6A 1K7

Ship to:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO K6A 1K7

Order No.: 35991

Sold By: LOWEY, ARLA

Shipped By:

Ship Date: 05/12/2017

Tracking No.:

Item No.	Unit	Description	Quantity	Backorder quantity
D2646P ✓	Each	Aft CAp ✓	50	
SPH \$19.				
Comment:				

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